



Dart Hawkesbury
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

Rush

D3173-041
Job Sheet 168203



Part No: D3173-041

Job Qty: 1 ea

Part Name: Beam Assembly



Part Weight: 0 lbs

Status: Scheduled

Priority: High

Job Created: 11/13/17

Job Tracking No:

Due Date: 11/14/17

Created By: Mario Poulin

Type: SOLD

Description:

Note: DWG REV B IPP A 02.12.05 New issue KJ/RF IPP Rev:B 08-09-25 update procedure DD verified by:EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea	11/13/17	11/13/17	0.00	0.00	Start Up Machining		Kt 17-11-14
100	Bandsaw	1 pcs	11/13/17	11/13/17	0.00	0.00	Bandsaw1		Kt 17-11-14
110	CNC Vertical Machining	1 pcs	11/13/17	11/13/17	0.00	0.51	HAAS 1		Kt 17-11-14
120	QC	1 pcs	11/13/17	11/13/17	0.00	0.00	QC2		Kt 17-11-14
130	QC	1 pcs	11/13/17	11/13/17	0.00	0.00	QC8		Kt 17-11-14
140	Mill Conv	1 pcs	11/13/17	11/13/17	0.00	0.58	Mill Conv 1		Kt 17-11-14
150	QC	1 pcs	11/13/17	11/13/17	0.00	0.00	QC5		38
160	HandFinish	1 pcs	11/13/17	11/13/17	0.00	0.29	HandFinish1		BEB 2017/11/14
170	QC	1 pcs	11/13/17	11/13/17	0.00	0.00	QC3		BEB 17-11-14
180	Powdercoat	1 pcs	11/13/17	11/13/17	0.00	0.09	Powdercoat1		BR 17-11-14
190	QC	1 pcs	11/13/17	11/13/17	0.00	0.00	QC3		
200	Small Fab	1 pcs	11/14/17	11/14/17	0.00	0.58	Small Fab		
210	QC	1 pcs	11/14/17	11/14/17	0.00	0.00	QC5		
220	Packaging	1 pcs	11/14/17	11/14/17	0.00	0.00	Packaging3		
230	QC21-SA	1 Ea	11/14/17	11/14/17	0.00	0.00	QC21		

Part Op 100 - Cut blank: 56" long Machine holes as per Folio FA295 and Dwg D3173 Identify as D3173-1

Descriptions: 110 - Machine holes as per Folio FA295 and Dwg D3173 Identify as D3173-1

120 - NULL

130 - NULL

140 - 1-Drill Ø0.316" holes as per Dwg D3173 2-C'sink holes as per Dwg D3173 3-deburr

150 - NULL

160 - NULL

170 - NULL

180 - Ensure Nut Plate thread is covered. START TIME: 4:20 OVEN TEMPERATURE: 320° FINISH

TIME: 4:50

190 - NULL

200 - Assemble per Dwg D3173. Install Mounting Lug as per Dwg D3173. D3175-041 is included in K10017 BOM.

210 - NULL

220 - NULL

230 - NULL

Job Allocations

Operation	Component Part	Required	Inventory	Allocated	Std Qty
90-Start up Operation	M6061T6TR4.0X2.0W125	5	38	0	0
200-Small Fab	AN3-5A FM13743-40	8	260	0	0
	AN5-23A FM134943.80	2	28	0	0

WORK ORDER NON-CONFORMANCE / UPDATE

DART
AEROSPACE

QA Closed:

Date:

Work Order update only

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐							
Date :	Step #	Job No: 168203 Mfg Date: 11/14/17 Start up Operation PART NO: D3173-041 Operation: Change No: Revision: Beam Assembly  S009548 DART AEROSPACE		MRB (Q51042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval							
Description Work Ord											
Root Cause <table style="width:100%; border-collapse: collapse;"> <tr> <td style="width:50%; vertical-align: top;"> Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ </td> <td style="width:50%; vertical-align: top;"> No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐ </td> </tr> </table>		Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	DART Aerospace Ltd. 1270 Aberdeen Street Hawkesbury, ON K6A 1K7 CANADA TEL: 1 613 632-5200 Email: sales@dartaero.com www.dartaerospace.com <table style="width:100%; border-collapse: collapse;"> <tr> <td style="width:50%; vertical-align: top;"> ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter </td> <td style="width:50%; vertical-align: top;"> ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes </td> </tr> </table>		☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter	☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes	<table style="width:100%; border-collapse: collapse;"> <tr> <td style="width:50%; vertical-align: top;"> ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center </td> <td style="width:50%; vertical-align: top;"> ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence </td> </tr> </table>		☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center	☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence
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		OTHER : ☐									

NT51147D0363J FM137965-13
 NAS1147D0563J AN960JD10 8 0 0 0
 AN960JD516 FM138209-14 4 0 0 0
 ← D3175-041 S003373 S009967 - 2 2 0 0
 D3178-041 S009137 2 0 0 0
 MS20601-AD4W4 F113749 8 532 0 0
 MS21042L5 S000558 2 413 0 0

Part Specifications

Specifications could not be found.

Plex 11/13/17 8:13 AM dart.poulin.mario

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Description Work Order Deviation		Disposition			

Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
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